

**SEMICONDUCTOR MULTI-PACKAGE MODULE INCLUDING STACKED-DIE PACKAGE
AND HAVING WIRE BOND INTERCONNECT BETWEEN STACKED PACKAGES**

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims the benefit of U.S. Provisional Application No. 60/411,590,
5 filed 17 September 2002, which is hereby incorporated herein by reference.

[0002] This application is related to U.S. Application No. (Atty Docket No. CPAC.1017-2),
titled "Semiconductor multi-package module having wire bond interconnection between
stacked packages"; U.S. Application No. (Atty Docket No. CPAC.1017-3), titled
"Semiconductor multi-package module having package stacked over ball grid array package
10 and having wire bond interconnection between stacked packages"; U.S. Application No. (Atty
Docket No. CPAC.1017-4), titled "Semiconductor multi-package module having wire bond
interconnect between stacked packages and having electrical shield"; U.S. Application No.
(Atty Docket No. CPAC.1017-5), titled "Semiconductor multi-package module having package
stacked over die-up flip chip ball grid array package and having wire bond interconnect
15 between stacked packages"; U.S. Application No. (Atty Docket No. CPAC.1017-6), titled
"Semiconductor multi-package module having package stacked over die-down flip chip ball
grid array package and having wire bond interconnect between stacked packages". This
application and all the said related applications are being filed on the same date, and each of
the said related applications is hereby incorporated herein by reference.

BACKGROUND

[0003] This invention relates to semiconductor packaging.

[0004] Portable electronic products such as mobile phones, mobile computing, and
various consumer products require higher semiconductor functionality and performance in a
limited footprint and minimal thickness and weight at the lowest cost. This has driven the
25 industry to increase integration on the individual semiconductor chips.

[0005] More recently the industry has begun implementing integration on the "z-axis," that
is, by stacking chips, and stacks of up to five chips in one package have been used. This
provides a dense chip structure having the footprint of a one-chip package, in the range of
5 x 5 mm to 40 x 40 mm, and obtaining thicknesses that have been continuously decreasing
30 from 2.3 mm to 0.5 mm. The cost of a stacked die package is only incrementally higher than
the cost of a single die package and the assembly yields are high enough to assure a
competitive final cost as compared to packaging the die in individual packages.

[0006] The primary practical limitation to the number of chips that can be stacked in a
stacked die package is the low final test yield of the stacked-die package. It is inevitable that
35 some of the die in the package will be defective to some extent, and therefore the final
package test yield will be the product of the individual die test yields, each of which is always

- 2 -

less than 100 %. This can be particularly a problem even if only two die are stacked in a package but one of them has low yield because of design complexity or technology.

[0007] Another limitation is the low power dissipation of the package. The heat is transmitted from one die to the other and there is no significant dissipation path other than through the solder ball to the motherboard.

[0008] A further limitation is electromagnetic interference between the stacked die, particularly between RF and digital die, because there is no electrical shielding of either die.

[0009] Another approach to integrating on the "z-axis" is to stack die packages to form a multi-package module. Stacked packages can provide numerous advantages as compared to stacked-die packages.

[0010] For instance, each package with its die can be electrically tested, and rejected unless it shows satisfactory performance, before the packages are stacked. As a result the final stacked multi-package module yields are maximized.

[0011] More efficient cooling can be provided in stacked packages, by inserting a heat spreader between the packages in the stack as well as at the top of the module.

[0012] Package stacking allows electromagnetic shielding of the RF die and avoids interference with other die in the module.

[0013] Each die or more than one die can be packaged in a respective package in the stack using the most efficient first level interconnect technology for the chip type and configuration, such as wire bonding or flip chip, to maximize performance and minimize cost.

[0014] The z-interconnect between packages in a stacked multi-package module is a critical technology from the standpoint of manufacturability, design flexibility and cost. Z-interconnects that have been proposed include peripheral solder ball connection, and flexible substrate folded over the top of the bottom package. The use of peripheral solder balls for z-interconnects in stacked multi-package modules limits the number of connections that can be made and limits design flexibility, and results in a thicker and higher cost package. Although the use of a flexible folding substrate provides in principle for design flexibility, there is no established manufacturing infrastructure for the folding process. Moreover, the use of a flexible folding substrate requires a two metal layer flex substrate, and these are expensive. Furthermore the folded flexible substrate approach is restricted to low pincount applications because of limits in routing the circuitry in two metal layer substrates.

[0015] The various z-interconnect structures are described in further detail with reference to FIGS. 1 - 4.

[0016] FIG. 1 is a diagrammatic sketch in a sectional view illustrating the structure of a standard Ball Grid Array ("BGA") package, well established in the industry, that can be used as a bottom package in a stacked multi-package module ("MPM"). The BGA, shown generally at 10, includes a die 14 attached onto a substrate 12 having at least one metal layer. Any of

various substrate types may be used, including for example: a laminate with 2 - 6 metal layers, or a build up substrate with 4 - 8 metal layers, or a flexible polyimide tape with 1 - 2 metal layers, or a ceramic multilayer substrate. The substrate **12** shown by way of example in FIG. **1** has two metal layers **121**, **123**, each patterned to provide appropriate circuitry and connected by way of vias **122**. The die is conventionally attached to a surface of the substrate using an adhesive, typically referred to as the die attach epoxy, shown at **13** in FIG. **1** and, in the configuration in FIG. **1**, the surface of the substrate onto which the die is attached may be referred to as the "upper" surface, and the metal layer on that surface may be referred to as the "upper" metal layer, although the die attach surface need not have any particular orientation in use.

[0017] In the BGA of FIG. **1** the die is wire bonded onto wire bond sites on the upper metal layer of the substrate to establish electrical connections. The die **14** and the wire bonds **16** are encapsulated with a molding compound **17** that provides protection from ambient and from mechanical stress to facilitate handling operations, and provides a surface for marking for identification. Solder balls **18** are reflowed onto bonding pads on the lower metal layer of the substrate to provide interconnection to the motherboard (not shown in the FIGS.) of a final product, such as a computer. Solder masks **125**, **127** are patterned over the metal layers **121**, **123** to expose the underlying metal at bonding sites for electrical connection, for example the wire bond sites and bonding pads for bonding the wire bonds **16** and solder balls **18**.

[0018] FIG. **2** is a diagrammatic sketch in a sectional view illustrating the structure of an example of a 2-stack MPM, generally at **20**, in which the z-interconnect between the packages in the stack is made by way of solder balls. In this MPM a first package (which may be referred to as the "bottom" package) is similar to a standard BGA as shown in FIG. **1** (and similar reference numerals are employed to point to similar features of the bottom package in FIGS. **1** and **2**). A second package (which may be referred to as the "top" package) is stacked on the bottom package and is similar in structure to the bottom package, except that the solder balls in the top package are arranged at the periphery of the top package substrate, so that they effect the z-interconnect without interference with the encapsulation of the bottom BGA. Particularly, the top package in FIG. **2** includes a die **24** attached onto a substrate **22** having at least one metal layer. The top package substrate **22** shown by way of example in FIG. **2** has two metal layers **221**, **223**, each patterned to provide appropriate circuitry and connected by way of vias **222**. The die is conventionally attached to a surface of the substrate (the "upper" surface) using an adhesive, typically referred to as the die attach epoxy, shown at **23** in FIG. **2**.

[0019] In the top package in the MPM of FIG. **2**, as in the bottom package, the die is wire bonded onto wire bond sites on the upper metal layer of the substrate to establish electrical

connections. The top package die **24** and wire bonds **26** are encapsulated with a top package molding compound **27**. Solder balls **28** are reflowed onto bonding pads located on the peripheral margin of the lower metal layer of the top package substrate to provide z-interconnection to the bottom package. Solder masks **225**, **227** are patterned over the metal layers **221**, **223** to expose the underlying metal at bonding sites for electrical connection, for example the wire bond sites and bonding pads for bonding the wire bonds **26** and solder balls **28**.

[0020] The z-interconnection in the MPM of FIG. **2** is achieved by reflowing the solder balls **28** attached to peripheral bonding pads on the lower metal layer of the top package substrate onto peripheral bonding pads on the upper metal layer of the bottom BGA. In this configuration the distance h between the top and bottom packages must be at least as great as the encapsulation height of the bottom package, which may be 0.3 mm or more, and typically is in a range between 0.5 mm and 1.5 mm. The solder balls **28** must accordingly be of a sufficiently large diameter that when they are reflowed they make good contact with the bonding pads of the bottom BGA; that is, the solder ball **28** diameter must be greater than the encapsulation height. A larger ball diameter dictates a larger ball pitch that in turn limits the number of balls that can be fitted in the available space. Furthermore the peripheral arrangement of the solder balls forces the bottom BGA to be significantly larger than the mold cap of a standard BGA. In small BGAs, usually referred to as Chip Scale Packages ("CSP"), the package body size is 1.7 mm larger than the die. In standard BGAs the body size is about 2 mm larger than the mold cap. In this configuration the top package substrate must have at least 2 metal layers to facilitate the electrical connections.

[0021] FIG. **3** is a diagrammatic sketch in a sectional view illustrating the structure of an example of a known 2-stack flip chip MPM, shown generally at **30**. In this configuration the bottom BGA flip chip package includes a substrate **32** having a patterned metal layer **31** onto which the die **34** is connected by flip chip bumps **36**, such as solder bumps, gold stud bumps or anisotropically conducting film or paste. The flip chip bumps are affixed to a patterned array of bump pads on the active surface of the die and, as the active surface of the die faces downward in relation to an upward-facing patterned metal layer of the substrate, such an arrangement may be referred to as a "die down" flip chip package. A polymer underfill **33** between die and substrate provides protection from ambient and adds mechanical integrity to the structure. Such a flip chip package, in which the substrate has a metal layer on only the upper surface, is connected to the underlying circuitry (such as a motherboard, not shown in the FIG.) by solder balls **38** connected to the metal layer through solder vias **35**.

[0022] The top BGA in this configuration is similar to the bottom BGA, except that the top BGA has z-interconnect solder balls **338** connected (through solder vias **335** in the top substrate) to the metal layer **331** only at the periphery of the top substrate. Solder balls **338**

are reflowed onto the metal layer **31** of the bottom substrate to provide the z-interconnect. Particularly, the top BGA in this configuration includes a substrate **332** having a patterned metal layer **331** onto which the top BGA die **334** is connected by flip chip bumps **336**.

Between the top BGA die and substrate is a polymer underfill **333**. A structure as in FIG. **3** is more appropriate for high electrical performance applications, but it has similar limitations to configurations of the type shown in of FIG. **2**. It presents an improvement over the FIG. **2** configuration in that the bottom BGA has no molding, allowing for use of smaller diameter (*h*) solder balls at the periphery of the top BGA for connection between the packages.

[0023] FIG. **4** is a diagrammatic sketch in a sectional view illustrating the structure of an example of a known 2-stack folded flexible substrate MPM, shown generally at **40**. The bottom package in the configuration of FIG. **4** has a 2-metal layer flexible substrate onto which the die is bonded via small beams to the first metal layer of the substrate. The second metal layer of the bottom package substrate carries the solder balls for connection to the underlying circuitry, such as a motherboard (not shown). The substrate is large enough to be folded over the top of the package, thus bringing the electrical interconnect lines upward where they are available for connection to the top package (an example of which is described below) by way of an array of solder balls on the top package. The space around the die and between the die and folded-over substrate is encapsulated to provide protection and rigidity.

[0024] Referring to FIG. **4**, the two-metal layer bottom package substrate **42** includes a first metal layer **141** and a second metal layer **143**, each patterned to provide appropriate circuitry and connected by way of vias **142**. A part of the first metal layer, over a part of the bottom substrate, is processed (for example, using an array of punches) to present an array of cantilever beams or tabs **46** arranged to correspond to an array of interconnect pads on the active surface of the bottom package die **44**. Over this part of the substrate **42**, which may be referred to as the "die attach part", the first metal layer **141** faces upwardly. The die is aligned, active surface downward, over the die attach part of the substrate, and the cantilevers and the corresponding interconnect pads are joined, typically for example by a "thermosonic" process employing a combination of pressure, heat, and ultrasonic energy to complete the electrical connections. The die **44** is affixed using an adhesive **43**, typically a die attach epoxy, onto the die attach part of the flexible substrate **42**. A second metal layer **143** of the bottom package substrate **42** faces downwardly in the die attach part of the substrate. Solder balls **48** are reflowed onto bonding pads located on an array on the downward-facing part of the second metal layer **143** to provide for interconnection of the MPM to underlying circuitry (not shown). A solder mask **147** is patterned over the second metal layer **143** to expose the underlying metal as bonding sites for electrical connection, including the bond pads for connection with the underlying circuitry by way of solder balls **48**, and the bond pads for connection with the top package by way of solder balls **18**, as described below.

- 6 -

[0025] Another part of the bottom package substrate **42**, extending adjacent the die-attach portion, is folded up and over the bottom package die **44**. On this folded-over portion of the flexible substrate **42** the first metal layer **143** faces upwardly. In the configuration of FIG. **4** the top package is generally similar to the BGA of FIG. **1**, in which the die is wire bonded onto wire bond sites on the upper metal layer of the substrate to establish electrical connections. Particularly, the top package die **14** is attached onto a substrate **12** having (in this example) two metal layers **121**, **123**, each patterned to provide appropriate circuitry and connected by way of vias **122**. The die is conventionally attached to the upper surface of the top package substrate using an adhesive **13**, typically a die attach epoxy. The die **14** and the wire bonds **16** are encapsulated with a molding compound **17** that provides protection from ambient and from mechanical stress to facilitate handling operations, and provides a surface for marking for identification. Solder balls **18** are reflowed onto bonding pads **143** on the upward-facing metal layer of the folded-over bottom package substrate to provide z-interconnection between the top and the bottom packages.

[0026] An advantage of a structure as in FIG. **4** is that the folded-over substrate provides sufficient area on the upward-facing surface of the folded-over bottom package substrate to accommodate a full array of solder balls in the top package and to accommodate more complex interconnect between the two packages. It also provides for a small package footprint. A primary disadvantage of this configuration is the high cost of the substrate and the unavailability of folding technology and equipment.

[0027] A common feature of all these stacked package configurations is that they enable pretesting of each package, and provide for production MPMs with higher final test yields.

SUMMARY

[0028] This invention is directed to multi-package modules having stacked packages. According to the invention, z-interconnection between the stacked packages in the MPM is wire bond based. Generally, the invention features various configurations of various stacked packages, and methods for stacking and interconnecting the various packages by wire-bonding based z-interconnection. In the multi-package module according to the invention the package stack can include any of a variety of BGA packages and/or any of a variety of Land Grid Array ("LGA") packages; the package stack can include wire bonded and/or flip chip packages; the package stack can include a thermal enhancement feature enabled by one or more heat spreaders in or on the stack; the package stack can include one or more packages having a flip chip die bonded either to the top or to the bottom of the BGA or LGA; the package stack can include one or more BGA and/or LGA packages having more than one die in the package stacked or side by side; the stack can include electromagnetic shield for one or more of the packages; and the stack can include any substrate, laminate or build-up or flexible

or ceramic, provided that the z-interconnect pads are made available for bonding on the periphery of the packages.

[0029] In one general aspect the invention features a multi-package module having stacked lower and upper packages, each package including a die attached to a substrate, in which the upper and lower substrates are interconnected by wire bonding.

[0030] The invention provides for excellent manufacturability, high design flexibility, and low cost to produce a stacked package module having a low profile and a small footprint. The wire bond z-interconnect is well established in the industry; it is the lowest cost interconnect technique and it is directly applicable, without significant modification, to the stacked multi-package modules of the invention. It provides design flexibility to the relative size of the BGA to LGA that can be bridged by wire length. Using available techniques and equipment the wire in a wire bond can be as short as 0.5 mm or as long as 5 mm. The arrangement of the z-interconnect pads can be implemented through either or both BGA and LGA substrate designs. Moreover, using wire bonds according to the invention z-interconnect can be formed between pads that are not precisely aligned over one another, by employing so-called "out of sequence bonding" that is in current use in the industry. The wire bonding pitch is the finest available technology in the industry at 50 microns currently, and projected to go to 25 microns. This enables a high number of z-interconnects. Both manufacturability and design flexibility contribute to the low cost of the MPM.

[0031] A minimum footprint for a typical BGA or LGA is 1.7 mm larger than the die size. The addition of the z-interconnect bond pads according to the invention will increase the BGA size minimally, by 0.8 mm. A typical BGA thickness is 1.0 mm and LGA thickness is 0.8 mm. A typical adhesive thickness can be in the range 0.025 mm to 0.100 mm. Both the footprint and the thickness of the stacked package MPM according to the invention fall within accepted ranges for most applications.

[0032] In some embodiments the multi-package module includes three or more packages, affixed serially to form a stack.

[0033] In another aspect the invention features a multi-package module having stacked first ("bottom") and second ("top") packages, each package including a die attached to a substrate and connected to the substrate by wire bonding, in which the top package substrate and the bottom package substrate are interconnected by wire bonding. In some embodiments each package is fully encapsulated with a molding material; in other embodiments at least one of the packages is encapsulated only to an extent sufficient to protect the wire bonds between the die and the substrate during subsequent handling and testing. In some embodiments the second package is an LGA package, and in some such embodiments the LGA package substrate is a single-metal layer substrate.

[0034] In another aspect the invention features a multi-package module having stacked first ("bottom") and second ("top") packages, each package including a die attached to a substrate and connected to the substrate by wire bonding, in which the top package substrate and the bottom package substrate are interconnected by wire bonding, and in which at least one of the bottom package and the top package is a stacked-die package. In some embodiments both the top package and the bottom package is a stacked-die package.

[0035] In another general aspect the invention features methods for making multi-package modules, by providing a first (bottom) package including at least one die on a first (bottom) package substrate, placing over the first package a second (top) package including at least one die on a second (top) package substrate, and forming wire bond z-interconnects between the first and second (top and bottom) substrates. Advantageously, the packages can be tested prior to assembly, and packages not meeting requirements for performance or reliability can be discarded, so that preferably only first packages and second packages tested as "good" are used in the assembled module.

[0036] In one aspect the invention features a method for making a multi-package module including a LGA package stacked over a stacked die package, in which the top and bottom packages are electrically interconnected by wire bonding. According to this aspect, a stacked die package is provided, usually in an unsingulated strip of stacked die packages; preferably the stacked die packages in the strip are tested for performance and reliability and packages identified as "good" are subjected to subsequent treatment; adhesive is dispensed over the upper surface of the "good" stacked die packages; a singulated molded land grid array package is provided; preferably the LGA package is tested and identified as "good"; the "good" LGA package is placed onto the adhesive over the "good" stacked die package, and the adhesive is cured; optionally and preferably a plasma clean operation is performed followed by formation of wire bond z-interconnections between the stacked top LGA and bottom BGA package; optionally and preferably an additional plasma clean may be performed, followed by the formation of the MPM molding. Further steps include attachment of second-level interconnect solder balls to the underside of the module; testing and singulation of the completed module from the strip, for example by saw singulation or by punch singulation; and packaging for further use.

[0037] In some embodiments the LGA (top) package is fully molded, providing a generally planar upper surface of the LGA package; in other embodiments the wire bonds but not the entire upper die surface of the LGA package is molded, molding of the LGA being carried out by dispensing the molding compound only around the periphery of the die and the margin of the LGA package substrate

[0038] In some embodiments the method includes steps for providing the multi-package module with a heat spreader. In this aspect of the invention a similar process is performed,

with additional steps interposed installation of supported heat spreader by a "drop-in" mold operation, or for installation of a simple planar heat spreader by a drop-in mold operation; or by applying adhesive onto an upper surface of the top package molding or onto an upper surface of a spacer upon the top package, and affixing the planar heat spreader onto the adhesive.

[0039] In another aspect the invention features a method for making a multi-package module including a top package stacked over a stacked die bottom package, in which the top and bottom packages are electrically interconnected by wire bonding. According to this aspect, a stacked die BGA package, usually molded, is provided, usually as an unsingulated strip of stacked die ball grid array packages is provided; preferably the BGA packages in the strip are tested for performance and reliability and packages identified as "good" are subjected to subsequent treatment; adhesive is dispensed over the upper surface of the "good" stacked die BGA package, usually on the generally planar upper surface of the package molding; a singulated second package is provided, usually molded, which may optionally be a stacked die package; preferably the second package is tested and identified as "good"; the "good" second package is placed onto the adhesive over the upper surface of the BGA, and the adhesive is cured; optionally and preferably a plasma clean operation is performed followed by formation of wire bond z-interconnections between the stacked top and bottom packages; optionally and preferably an additional plasma clean may be performed, followed by the formation of the MPM molding. Further steps include attachment of second-level interconnect solder balls to the underside of the module; testing and singulation of the completed module from the strip, for example by saw singulation or by punch singulation; and packaging for further use.

[0040] In some embodiments of the method two or more first molded packages are provided in an unsingulated strip, and assembly of the two or more modules proceeds on the strip, and singulation of the two or more modules is carried out after assembly has been completed.

[0041] In methods according to the invention for making multi-package modules the electrical connections between the stacked packages employs conventional wire bonding to form the z-interconnect between upper and lower package substrates in the stack. Particular advantages include the use of established manufacturing infrastructure, low production cost, design flexibility, and a thin package product. The z-interconnect wire bonding can be carried out, in the various package and module configurations, by drawing the wire to a conductive pad on the first package substrate from a bump formed on a conductive pad on the second package substrate; or, by drawing the wire to a conductive pad on the second package substrate from a bump formed on a conductive pad on the first package substrate.

[0042] The invention provides for assembly of more than one semiconductor in a thin and minimal footprint package at the lowest cost and highest final test yield. Furthermore some stack configurations according to the invention allow for high thermal performance, high electrical performance or electrical isolation of an RF component from a digital one. Other stack configurations provide a very thin structure appropriate for handheld or consumer products. All provide for a method for assembly that allows individual testing of the stacked packages to maximize the final yield of the module.

[0043] Additional process steps will be employed to complete the multi-package module according to the invention. For example, it may be preferred not to attach solder balls for connection of the lowermost package in the stack to the motherboard until the final step before singulation of the MPMs. And, for example, a plasma clean may be performed at any of a variety of points in the process, such as following adhesive cure and prior to encapsulation, and such as prior to and/or following z-interconnect wire bonding.

[0044] Advantageously, the individual packages can be provided as strips of several packages, connected in a row for ease of handling during manufacture, and the multi-package modules are singulated following completion of process steps. In methods according to the invention, the package stacks can be formed on a strip of nonsingulated first packages of a selected type by affixing singulated second packages and forming the wire bonded z-interconnects until the process of forming the modules is complete, and then singulating the modules.

[0045] MPM according to the invention can be used for building computers, telecommunications equipment, and consumer and industrial electronics devices.

BRIEF DESCRIPTION OF THE DRAWINGS

[0046] FIG. 1 is a diagrammatic sketch in a sectional view thru a conventional ball grid array semiconductor package.

[0047] FIG. 2 is a diagrammatic sketch in a sectional view thru a conventional multi-package module having solder ball z-interconnection between stacked ball grid array semiconductor packages.

[0048] FIG. 3 is a diagrammatic sketch in a sectional view thru a conventional flip chip multi-package module having solder ball z-interconnection between stacked flip chip semiconductor packages.

[0049] FIG. 4 is a diagrammatic sketch in a sectional view thru a conventional multi-package module having a folded flexible substrate and solder ball z-interconnection between stacked semiconductor packages.

[0050] FIG. 5A is a diagrammatic sketch in a sectional view thru an embodiment of a multi-package module having wire bond z-interconnection between stacked BGA and LGA semiconductor packages according to an aspect of the invention.

5 [0051] FIG. 5B is a diagrammatic sketch in a plan view showing a bottom BGA substrate having z-interconnect bond pads in an arrangement suitable for use in an embodiment of the invention as shown in FIG. 5A.

[0052] FIG. 5C is a diagrammatic sketch in a plan view showing a top LGA substrate having z-interconnect bond pads in an arrangement suitable for use in an embodiment of the invention as shown in FIG. 5A.

10 [0053] FIG. 5D is a diagrammatic sketch in a sectional view thru an embodiment of a multi-package module having wire bond z-interconnection between stacked BGA and LGA semiconductor packages according to an aspect of the invention, and having a heat spreader affixed to an upper surface of the top package.

15 [0054] FIG. 5E is a diagrammatic sketch in a sectional view thru an embodiment of a multi-package module having wire bond z-interconnection between stacked BGA and LGA semiconductor packages, and having a heat spreader according to another aspect of the invention.

20 [0055] FIG. 6A is a diagrammatic sketch in a sectional view thru a multi-package module having wire bond z-interconnection between stacked flip-chip BGA (die up) and stacked die LGA semiconductor packages according to a further aspect of the invention, in which adjacent stacked die in the second package are separated by a spacer.

25 [0056] FIG. 6B is a diagrammatic sketch in a sectional view thru a multi-package module having wire bond z-interconnection between stacked flip-chip BGA (die up) and stacked die LGA semiconductor packages according to a further aspect of the invention, in which adjacent stacked die in the second package are of different sizes.

[0057] FIG. 6C is a diagrammatic sketch in a sectional view thru a multi-package module having wire bond z-interconnection between stacked flip-chip BGA (die up) and stacked die LGA semiconductor packages according to a further aspect of the invention, and in which an electrical shield is provided on the bottom package.

30 [0058] FIG. 6D is a diagrammatic sketch in a sectional view thru a multi-package module having wire bond z-interconnection between stacked flip-chip BGA (die up) and stacked die LGA semiconductor packages according to a further aspect of the invention, and in which an electrical shield is provided on the bottom package, and having a heat spreader affixed to an upper surface of the top package.

35 [0059] FIG. 6E is a diagrammatic sketch in a sectional view thru a multi-package module having wire bond z-interconnection between stacked flip-chip BGA (die up) and stacked die LGA semiconductor packages according to a further aspect of the invention, and in which an

electrical shield is provided on the bottom package, and having a heat spreader according to another aspect of the invention.

[0060] FIG. 7 is a diagrammatic sketch in a sectional view thru a multi-package module having wire bond z-interconnection between stacked BGA (stacked die) and LGA (stacked die) semiconductor packages according to a further aspect of the invention.

[0061] FIG. 8 is a flow diagram showing a process for assembly of a multi-package module as shown for example in FIG. 6A or FIG. 6B.

[0062] FIG. 9 is a flow diagram showing a process for assembly of a multi-package module as shown for example in FIG. 9.

DETAILED DESCRIPTION

[0063] The invention will now be described in further detail by reference to the drawings, which illustrate alternative embodiments of the invention. The drawings are diagrammatic, showing features of the invention and their relation to other features and structures, and are not made to scale. For improved clarity of presentation, in the FIGS. illustrating embodiments of the invention, elements corresponding to elements shown in other drawings are not all particularly renumbered, although they are all readily identifiable in all the FIGS.

[0064] Turning now to FIG. 5A, there is shown in a diagrammatic sectional view generally at 50 an embodiment of a multi-package module according to an aspect of the invention, including stacked first ("bottom") and second ("top") packages, in which the stacked packages are interconnected by wire bonding. In the embodiment shown in FIG. 5A, the bottom package 400 is a conventional BGA package such as that shown in FIG. 1. Accordingly, in this embodiment the bottom package 400 includes a die 414 attached onto a bottom package substrate 412 having at least one metal layer. Any of various substrate types may be used, including for example: a laminate with 2 - 6 metal layers, or a build up substrate with 4 - 8 metal layers, or a flexible polyimide tape with 1 - 2 metal layers, or a ceramic multilayer substrate. The bottom package substrate 412 shown by way of example in FIG. 5A has two metal layers 421, 423, each patterned to provide appropriate circuitry and connected by way of vias 422. The die is conventionally attached to a surface of the substrate using an adhesive, typically referred to as the die attach epoxy, shown at 413 in FIG. 5A and, in the configuration in FIG. 5A, the surface of the substrate onto which the die is attached may be referred to as the "upper" surface, and the metal layer on that surface may be referred to as the "upper" metal layer, although the die attach surface need not have any particular orientation in use.

[0065] In the bottom BGA package of FIG. 5A the die is wire bonded onto wire bond sites on the upper metal layer of the substrate to establish electrical connections. The die 414 and the wire bonds 416 are encapsulated with a molding compound 417 that provides protection

from ambient and from mechanical stress to facilitate handling operations, and provides a bottom package upper surface **419** onto which a second ("top") package can be stacked. Solder balls **418** are reflowed onto bonding pads on the lower metal layer of the substrate to provide interconnection to underlying circuitry of, for example, a motherboard (not shown in the FIGS.) of a final product, such as a computer. Solder masks **415**, **427** are patterned over the metal layers **421**, **423** to expose the underlying metal at bonding sites for electrical connection, for example the wire bond sites and bonding pads for bonding the wire bonds **416** and solder balls **418**.

[0066] In the embodiment shown in FIG. **5A**, the top package **500** is a land grid array ("LGA") package, which may be similar to a BGA package, as shown for example in FIG. **1**, but having no solder balls mounted on bonding pads of the lower surface of the substrate. Particularly, in this example, the top package **500** includes a die **514** attached onto a top package substrate **512** having at least one metal layer. Any of various substrate types may be used; the top package substrate **512** shown by way of example in FIG. **5A** has two metal layers **521**, **523**, each patterned to provide appropriate circuitry and connected by way of vias **522**. The die is conventionally attached to a surface of the substrate using an adhesive, typically referred to as the die attach epoxy, shown at **513** in FIG. **5A** and, in the configuration in FIG. **5A**, the surface of the substrate onto which the die is attached may be referred to as the "upper" surface, and the metal layer on that surface may be referred to as the "upper" or "top" metal layer, although the die attach surface need not have any particular orientation in use.

[0067] In the top LGA package in the embodiment of FIG. **5A** the die is wire bonded onto wire bond sites on the upper metal layer of the substrate to establish electrical connections. The die **514** and the wire bonds **516** are encapsulated with a molding compound **517** that provides protection from ambient and from mechanical stress to facilitate handling operations, and has a top package upper surface **519**. The top package **500** is stacked over the bottom package **400** and affixed there using an adhesive **513**. Solder masks **515**, **527** are patterned over the metal layers **521**, **523** to expose the underlying metal at bonding sites for electrical connection, for example the wire bond sites for bonding the wire bonds **516**.

[0068] The z-interconnect between the stacked top package **500** and bottom package **400** is made by way of wire bonds **518** connecting the top metal layers of the respective package substrates. At one end each wire bond **518** is electrically connected to upper surfaces of pads on the upper metal layer **521** of the top package substrate **512**, and at the other end each wire bond is connected to the upper surfaces of pads on the upper metal layer **421** of the bottom package substrate **412**. The wire bonds may be formed by any wire bonding technique, well known in the art, such as is described, for example, in U.S. 5,226,582, which is hereby incorporated by reference herein. The package-to-package z-interconnect wire bonds are

shown by way of example in FIG. 5A as having been made by forming a bead or bump on the upper surface of a pad on the upper metal layer of the top substrate, and then drawing the wire downward toward and fusing it onto, a pad on the upper metal layer of the bottom substrate. As will be appreciated, the wire bonds can be made in the inverse direction, that is, by forming a bead or bump on the upper surface of a pad on the upper metal layer of the bottom substrate, and then drawing the wire upward toward and fusing it onto, a pad on the upper metal layer of the top substrate. As will be appreciated, selection of a wire bonding strategy for the package-to-package z-interconnection will be determined according to the geometric arrangements of the margins of the stacked substrates and of the bonding surfaces on them.

[0069] In the stacked package embodiment of FIG. 5A, the z-interconnect pads on the respective package substrates are arranged on the upper metal layers near the margins of the package substrates. The location and order of the z-interconnect pads are generally arranged so that the z-interconnect pads on the top package substrate approximately overlie the corresponding z-interconnect pads on the bottom package when the packages are stacked. Conveniently, the top package 500 has a smaller substrate footprint than that of the bottom package 400, to allow clearance for the wire bonds without electrical shorting to the edges of the metal layers of the substrates. Once the z-interconnect wire bonds have been formed, a module encapsulation is formed, to enclose and protect the z-interconnect wire bonds and to provide mechanical integrity to the completed module.

[0070] The arrangements of the z-interconnect pads on the top and bottom package substrates are shown by way of example in diagrammatic plan view in FIGS. 5B and 5C, generally at 500 and 400, respectively. Referring to Fig 5B, top package z-interconnect pads 524 are formed by patterning regions of the upper metal layer situated at the margin 501 on the upper surface 525 of the top package substrate 512. The margin 501 extends beyond the edge 526 of the top package encapsulant material, which has an upper surface 519. Referring now to FIG. 5C, bottom package z-interconnect pads 424 are formed by patterning regions of the upper metal layer situated at the margin 401 on the upper surface 425 of the top package substrate 412. The margin 401 extends beyond the footprint 511 of the stacked and overlying top package substrate 512, and further beyond the edge 426 of the bottom package encapsulant material, which has an upper surface 419.

[0071] As will be apparent from FIGS. 5A, 5B and 5C, z-interconnection between the top and bottom packages according to the invention is made by wire bond between (either bond-up or bond-down) the top package interconnect pads 524 in the margin 501 of the top package substrate and the bottom package interconnect pads 424 in the margin 401 of the bottom package substrate. The multipackage module structure is protected by formation of a module encapsulant 507, and solder balls 418 are reflowed onto exposed solder ball pads on

the lower metal layer of the bottom package substrate, for connection to underlying circuitry, such as a motherboard (not shown in the FIGS.).

[0072] As will be appreciated from the foregoing, the structure according to the invention allows for pre-testing of both the BGA and LGA before assembly into the multi-package module, to permit rejection of nonconforming packages prior to assembly, and thereby to assure high final module test yields.

[0073] For improved heat dissipation from the multi-package module, a heat spreader may be provided over the top package. The top heat spreader is formed of a thermally conductive material having at least the more central area of its upper surface exposed at the upper surface of the MPM to ambient for efficient heat exchange away from the MPM. The top heat spreader may be, for example, a sheet of metal (such as copper), and it may be affixed to the MPM encapsulant during the molding material curing process. Or, the heatspreader may have a generally planar portion over the top package, and a peripheral supporting portion or supporting members resting on or near the upper surface of the bottom package substrate.

[0074] By way of example, FIG. 5E is a diagrammatic sketch in a sectional view showing a stacked BGA + LGA MPM 54 according to another aspect of the invention, in which a "top" heat spreader is provided at the upper surface of the MPM. The construction of the stacked packages in MPM 54 is generally similar to that of MPM 50 in FIG. 5A, and like structures are identified in the FIGS. by like reference numerals. The top heat spreader in this example is formed of a thermally conductive material having a generally planar central portion 544 situated over the top package, and peripheral supporting members 546 extending to the upper surface of the bottom package substrate 412. The upper surface of the planar portion 544 is exposed to ambient at the MPM upper surface for efficient heat exchange away from the MPM. The top heat spreader may be formed, for example, of a sheet of metal (such as copper), for example by stamping. The supporting members 546 can optionally be affixed to the upper surface of the bottom package substrate using an adhesive (not shown in the FIGS.). The multi-package module structure is protected by formation of a module encapsulant 507, and the heat spreader supporting members are embedded in the MPM encapsulant 507 during the molding material curing process. In the embodiment of FIG. 5E a step like re-entrant feature 545 is provided on the periphery of the planar upper portion 544 of the heat spreader to allow for better mechanical integrity of the structure with less delamination from the molding compound. In this embodiment the space between the lower surface of the heat spreader 544 and the upper surface 519 of the LGA molding 917 is filled by a thin layer of the MPM molding.

[0075] Alternatively, a top heat spreader can be affixed to the upper surface of the LGA molding as shown diagrammatically in a sectional view in FIG. 5D. The construction of the stacked packages in MPM 52 is generally similar to that of MPM 50 in FIG. 5A, and like

structures are identified in the FIGS. by like reference numerals. The top heat spreader **504** in the example of FIG. **5D** is a generally planar piece of a thermally conductive material having at least the more central area of its upper surface exposed to ambient for efficient heat exchange away from the MPM, as in the example of FIG. **5E**. The top heat spreader may be, for example, a sheet of metal (such as copper). Here, however, the top heat spreader **504** is affixed onto the upper surface **519** of the upper package encapsulant **517** using an adhesive **506**. The adhesive **506** may be a thermally conductive adhesive, to provide improved heat dissipation. Usually the top heat spreader is affixed to the top package molding after the top package molding has been at least partly cured, but before the molding material is injected for the MPM encapsulation **507**. The periphery of the top heat spreader may be encapsulated with the MPM molding material. In the embodiment of FIG. **5D** a step like re-entrant feature **505** is provided on the periphery of the heat spreader **504** to allow for better mechanical integrity of the structure with less delamination from the molding compound.

[0076] As a further alternative, an MPM as in FIG. **5A** can be provided with a simple planar heat spreader, with no supporting members, that is not attached to the upper surface of the top package molding. In such embodiments, as in the embodiment of FIG. **5D**, the top heat spreader can be a generally planar piece of a thermally conductive material such as, for example, a sheet of metal (such as copper), and at least the more central area of the upper surface of the planar heat spreader is exposed to ambient for efficient heat exchange away from the MPM. Here, the space between the lower surface of the simple planar heat spreader and the upper surface **519** of the LGA molding **517** may be filled by a thin layer of the MPM molding, and such a simple planar heat spreader may be affixed to the MPM encapsulant **507** during the molding material curing process. The periphery of such an unattached simple planar top heat spreader can be encapsulated with the MPM molding material, as in the attached planar heat spreader of FIG. **5D**, and may be provided with a step-like re-entrant feature **505** on the periphery to allow for better mechanical integrity of the structure with less delamination from the molding compound.

[0077] An MPM structure having a heat spreader, as in FIGS. **5D**, **5E**, can provide improved thermal performance.

[0078] The bottom package of the MPM according to the invention can be a flip chip package in a die-up configuration, in which the bottom package die is carried on the lower surface of the bottom package substrate. Usually the bottom package die attach region in such a configuration is situated about the center of the substrate area, and the second-level interconnect balls are arranged peripherally near two or (more usually) for of the substrate edges. The die-up flip chip and its flip chip interconnect structures are located within the standoff height of the second-level interconnect structures, and, accordingly, the bottom package die in such configurations contributes nothing to the overall thickness of the MPM.

- 17 -

Moreover, the die-up configuration can avoid a netlist inversion effect, which typically is a consequence of die-down configuration.

[0079] Particularly, by way of example, FIG. 6A is a diagrammatic sketch in a sectional view showing a multi-package module 101 according to another aspect of the invention, in which a stacked-die land grid array package 1000 is stacked over a flip chip BGA in a die-up configuration 302, and the stacked packages are interconnected by wire bonding. In the bottom BGA package 302 the die 344 is attached on the lower side of the BGA substrate 342.

[0080] As the FIG. illustrates, this structure provides for a thinner MPM because the bottom package die is on the underside of the bottom package in the area between the peripherally situated solder balls. Such a configuration can have a higher electrical performance not only because it employs a flip chip connection but also because it provides more direct electrical connection of the die to the solder balls, with shorter metal traces and without requiring vias for connection between the die and the solder balls. Furthermore the die-up configuration enables this package to be netlist compatible to wire bonding, as may be desired in some applications. Netlist is the sum of all pairs of connections between the die and the solder balls. When the die faces up "die-down" it has a connection pattern that is the mirror image of the pattern in the same die when the die is facing down "die-up".

[0081] In a configuration as in FIG. 6A the top LGA package is attached with adhesive onto the upper side of the BGA, and then is wire bonded and molded. In the embodiment shown by way of example in FIGS. 6A through 6E more than one die (two or more) are stacked in the top package. Stacked die packages are well established in the industry, with versions that have up to 5 stacked die in the package. The die have various sizes, and the die in a stacked die package may have the same or different relative sizes. The die are typically square or rectangular, and rectangular and square die of various dimensions may be stacked in a stacked die package. Where the die are rectangular, or have various dimensions, the die may be stacked so that the margin of a lower die in the stack projects beyond the margin of an upper die that is stacked over it. FIG. 6A shows an example in which the two die in the stack are of the same size. In such embodiments, or in embodiments where an upper die in the stack is larger than a lower one, a spacer is assembled between the die to enable wire bonding of all the die to the LGA substrate. FIG. 6B shows an example in which the upper die in the stack is smaller than a lower one; or, alternatively, the die are stacked so that the margin of the upper stack projects beyond the margin of the lower stack. In embodiments such as in FIG. 6B no spacer is necessary, because wire bond sites in the projecting margin of the lower die allows for wire bonding without interference from the die that is stacked over it.

[0082] Referring to FIG. 6A, the bottom flip chip BGA package 302 includes a substrate 342 having a patterned metal layer 353 onto parts of which the die 344 is connected

- 18 -

by flip chip bumps **346**, such as solder bumps, gold stud bumps or anisotropically conducting film or paste. Any of various substrate types may be used; the bottom package substrate **342** shown by way of example in FIG. **6A** has two metal layers **351**, **353**, each patterned to provide appropriate circuitry. Bottom package substrate **342** additionally has a metal layer **355** sandwiched between dielectric layers **354**, **356**. Metal layer **355** has voids at selected locations, to permit connection of the metal layers **351**, **353** by vias therethrough and, accordingly, selected parts of the patterned metal layers **351**, **353** are connected by way of vias through the substrate layers **354**, **356** and through the voids in the sandwiched metal layer **355**. Selected parts of the patterned metal layer **353** are connected by way of vias through substrate layer **356** to sandwiched metal layer **355**.

[0083] Flip chip bumps **346** are attached to a patterned array of bump pads on the active surface of the die and, as the active surface of the die faces upward in relation to an downward-facing patterned metal layer of the substrate, such an arrangement may be referred to as a "die up" flip chip package. A polymer underfill **343** between the die and the die attach region of the substrate provides protection from ambient and adds mechanical integrity to the structure.

[0084] As noted above, the metal layers **351**, **353** are patterned to provide appropriate circuitry, and the sandwiched metal layer **355** has voids at selected locations to allow interconnections (without contact with the sandwiched metal layer **355**) between selected traces on the upper and lower metal layers **351**, **353**. Particularly, for example, the lower metal layer is patterned in the die attach area to provide attachment sites for the flip chip interconnect bumps **353**; and, for example, the lower metal layer is patterned nearer the margin of the bottom package substrate **342** to provide attachment sites for the second-level interconnect solder balls **348**, by which the completed MPM is attached by solder reflow to underlying circuitry (not shown). And particularly, for example, the upper metal layer is patterned near the margin of the bottom package substrate **342** to provide attachment sites for wire bonds connecting the top package to the bottom package. Ground lines in the circuitry of metal layer **353** are connected through vias to the sandwiched metal layer **355**; selected ones of the solder balls **348** are ground balls, which will be attached to ground lines in the underlying circuitry when the MPM is installed. Thus, the sandwiched metal layer **355** serves as a ground plane for the MPM. Selected others of the solder balls **348** are input/output balls or power balls, and these are, accordingly, attached to solder ball sites on input/output or power lines, respectively, in the circuitry of metal layer **353**.

[0085] Referring still to FIG. **6A**, the top package **1000** is a stacked die land grid array package, having die **1014**, **1024** separated by a spacer **1015** and stacked over a top package substrate. The top package substrate includes a dielectric layer **1012** having a metal layer on the upper substrate surface, and patterned to provide traces, for example **1031**, provided with

attachment sites for wire bond interconnect of the top package substrate with the stacked die and for wire bond interconnect of the top package with the bottom package substrate. Lower die **1014** is attached to a die attach area of the top package substrate using an adhesive **1013** such as a die attach epoxy. Die **1014** is electrically connected to the top substrate by way of wire bonds **1016** connecting wire bond sites on the active surface of die with wire bond sites on selected traces **1011**. A spacer **1015** is affixed to the upper surface of the lower die **1014** using an adhesive (not shown in the FIG.), and upper die **1024** is affixed to the upper surface of the spacer **1015** using an adhesive (not shown). The spacer is selected to be sufficiently thick to provide clearance so that the overhanging margins of upper die **1024** do not impinge upon the wire bonds **1016**. Die **1024** is electrically connected to the top substrate by way of wire bonds **1026** connecting wire bond sites on the active surface of die with wire bond sites on selected traces **1011**. The assembly of stacked die and wire bonds over the top package substrate is encapsulated in a molding material **1017** providing a top package upper surface **1019**, and leaving marginal portions of the interconnect traces **1011** exposed. The top package **1000** may at this point be tested, and then stacked onto a die attach area of the upper surface of the bottom package substrate, and affixed there using an adhesive **1003**. Electrical interconnect of the top and bottom packages is effected by wire bonds **1018** connecting exposed wire bond sites on the traces **1011** of the top package substrate with wire bond sites on traces **351** of the upper metal layer of the bottom package substrate. The MPM assembly is then encapsulated in a molding **1007** to protect the package-to-package wire bonds and to provide mechanical integrity in the completed MPM **101**.

[0086] As noted above, the stacked die top package that is stacked over the die-up flip chip BGA package in such embodiments may have various configurations, depending for example upon the number of die in the stack, and upon the dimensions of the die. For

example, FIG. **6B** shows, in a diagrammatic sectional view, an alternative MPM configuration **103** in which the LGA has two stacked die and in which the upper die **1044** has a smaller dimension than the lower die **1034**, at least in the plane of the sectional view. In such a configuration there is no marginal overhang of the upper die over the wire bond attachment sites in the margin of the lower die, and so it is unnecessary to include a spacer. The bottom package **302** in MPM **103** of FIG. **6B** is substantially similar to the bottom package in MPM **101** of FIG. **6A**, and corresponding parts are similarly identified in the FIGS. The top package **1030** in MPM **103** is a stacked die land grid array package, having die **1034**, **1044** stacked over a top package substrate. The top package substrate includes a dielectric layer **1012** having a metal layer on the upper substrate surface, and patterned to provide traces, for example **1031**, provided with attachment sites for wire bond interconnect of the top package substrate with the stacked die and for wire bond interconnect of the top package with the bottom package substrate. Lower die **1034** is attached to a die attach area of the top package

substrate using an adhesive **1033** such as a die attach epoxy. Die **1034** is electrically connected to the top substrate by way of wire bonds **1036** connecting wire bond sites on the active surface of die with wire bond sites on selected traces **1031**. Upper die **1044** is affixed to the upper surface of lower die **1034** using an adhesive **1035**. Die **1044** is electrically connected to the top substrate by way of wire bonds **1046** connecting wire bond sites on the active surface of die with wire bond sites on selected traces **1031**. The assembly of stacked die and wire bonds over the top package substrate is encapsulated in a molding material **1037** providing a top package upper surface **1039**, and leaving marginal portions of the interconnect traces **1031** exposed. The top package **1030** may at this point be tested, and then stacked onto a die attach area of the upper surface of the bottom package substrate, and affixed there using an adhesive **1003**. Electrical interconnect of the top and bottom packages is effected by wire bonds **1018** connecting exposed wire bond sites on the traces **1031** of the top package substrate with wire bond sites on traces **351** of the upper metal layer of the bottom package substrate. The MPM assembly is then encapsulated in a molding **1007** to protect the package-to-package wire bonds and to provide mechanical integrity in the completed MPM **103**.

[0087] The processor chip in a flip chip bottom package according to this aspect of the invention can be, for example, an ASIC, or a GPU, or a CPU; and the top package can be a memory package, particularly for example, as illustrated in FIGS. **16A**, **6B**, a stacked die memory package. A flip chip die-up configuration for the bottom package can provide a very thin module, and can be particularly suitable for higher speed applications such as mobile communications.

[0088] As will be appreciated, the ground plane **355** in the bottom package substrate in an embodiment such as MPM **101** or **103** additionally serves as an electromagnetic shield to significantly reduce interference between the BGA die and the overlying LGA die, and such a MPM can be particularly useful in applications where the bottom package die is a high frequency (e.g., radio frequency) die.

[0089] In some applications it may be desirable also to shield the BGA die in the bottom package from the underlying circuitry to which the MPM is attached. FIG. **6C** shows an example of a multi-package module **105** in which a stacked-die land grid array package **1000** is stacked over a flip chip BGA in a die-up configuration **302**, in which the stacked packages are interconnected by wire bonding, and in which an electromagnetic shield is provided at the flip chip BGA die to limit radiation downward toward the underlying circuitry (not shown).

[0090] In the MPM **105** of FIG. **6C** the top package **1000** and the bottom package **302** are constructed substantially as in MPM **101** of FIG. **6A**, and corresponding features are correspondingly identified in the FIGS. The bottom package **302** of MPM **105** is provided with a metallic (for example, copper) electrical shield to electrically contain electromagnetic radiation from the die in the lower BGA and thereby prevent interference with circuitry

underlying the installed MPM. A lower planar part of the shield **304** is supported by legs or sidewalls **305**. Spots or lines **306** of an adhesive serve to affix the heat spreader support **305** to the lower surface of the bottom substrate. The adhesive can be a conductive adhesive, and can be electrically connected to traces in the lower metal layer of the substrate, particularly to ground traces of the circuit. The supporting parts and the lower planar part of the shield enclose the die **344** and, in addition to shielding the lower die in the completed device, can serve to protect the lower die from ambient and from mechanical stress to facilitate handling operations and, particularly, during subsequent testing before assembly of the MPM or before installation.

[0091] Alternatively, as will be appreciated, a shield as described with reference to FIG. **6C** can be employed to shield a die-up flip chip bottom package **302** in MPM having other stacked die top package configurations. The stacked die top package may, for example, have no spacer between adjacent die, as shown generally at **1030** in FIG. **6B**.

[0092] And alternatively, a shield as described with reference to FIG. **6C** can be employed to shield a die-up flip chip bottom package **302** in MPM having top packages other than stacked die top packages. The top package may, for example, be a land grid array package, such as for example the LGA top package shown generally at **500** in FIG. **5A**.

[0093] Moreover, for improved heat dissipation from a multi-package module configured generally as in FIG. **6A**, a heat spreader may be provided over the top package. The top heat spreader is formed of a thermally conductive material having at least the more central area of its upper surface exposed at the upper surface of the MPM to ambient for efficient heat exchange away from the MPM. The top heat spreader may be, for example, a sheet of metal (such as copper), and it may be affixed to the MPM encapsulant during the molding material curing process. Or, the heatspreader may have a generally planar portion over the top package, and a peripheral supporting portion or supporting members resting on or near the upper surface of the bottom package substrate.

[0094] By way of example, FIG. **6E** is a diagrammatic sketch in a sectional view showing a MPM **109**, including a stacked die top package stacked over a die-up flip chip bottom BGA, in which a "top" heat spreader is provided at the upper surface of the MPM. The construction of the top and bottom packages in MPM **109** is generally similar to that of MPM **105** in FIG. **6C**, and like structures are identified in the FIGS. by like reference numerals. The top heat spreader in this example is formed of a thermally conductive material having a generally planar central portion **1044** situated over the top package **1000**, and peripheral supporting members **1046** extending to the upper surface of the bottom package substrate **342**. The upper surface of the planar portion **1044** is exposed to ambient at the MPM upper surface for efficient heat exchange away from the MPM. The top heat spreader may be formed, for example, of a sheet of metal (such as copper), for example by stamping. The supporting

members **1046** can optionally be affixed to the upper surface of the bottom package substrate using an adhesive (not shown in the FIGS.). The multi-package module structure is protected by formation of a module encapsulant **1007**, and the heat spreader supporting members are embedded in the MPM encapsulant **1007** during the molding material curing process. In the embodiment of FIG. **10E** a step like re-entrant feature **1045** is provided on the periphery of the planar upper portion **1044** of the heat spreader to allow for better mechanical integrity of the structure with less delamination from the molding compound. In this embodiment the space between the lower surface of the heat spreader **1044** and the upper surface **1019** of the LGA molding **1017** is filled by a thin layer of the MPM molding.

[0095] Alternatively, the top heat spreader can be a generally planar piece of a thermally conductive material such as, for example, a sheet of metal (such as copper), with no supporting members. At least the more central area of the upper surface of the planar heat spreader is exposed to ambient for efficient heat exchange away from the MPM. Such a simple planar heat spreader is shown in FIG. **6D** at **1004**, where the heat spreader is affixed to an upper surface of the top package molding. The construction of the stacked packages in MPM **1004** is generally similar to that of MPM **1044** in FIG. **6E**, and like structures are identified in the FIGS. by like reference numerals. The top heat spreader **1004** in the example of FIG. **6D** is a generally planar piece of a thermally conductive material having at least the more central area of its upper surface exposed to ambient for efficient heat exchange away from the MPM, as in the example of FIG. **6E**. The top heat spreader may be, for example, a sheet of metal (such as copper). Here, however, the top heat spreader **1004** is affixed onto the upper surface **1019** of the upper package encapsulant **1017** using an adhesive **1006**. The adhesive **1006** may be a thermally conductive adhesive, to provide improved heat dissipation. Usually the top heat spreader is affixed to the top package molding after the top package molding has been at least partly cured, but before the molding material is injected for the MPM encapsulation **1007**. The periphery of the top heat spreader may be encapsulated with the MPM molding material. In the embodiment of FIG. **6D** a step like re-entrant feature **1005** is provided on the periphery of the heat spreader **1004** to allow for better mechanical integrity of the structure with less delamination from the molding compound.

[0096] It is not necessary that a simple planar heat spreader, such as **1004** in FIG. **6D**, be attached to the upper surface of the top package molding. Instead, the space between the lower surface of the simple planar heat spreader and the upper surface **1019** of the LGA molding **1017** can be filled by a thin layer of the MPM molding, and such a simple planar heat spreader may be affixed to the MPM encapsulant **1007** during the molding material curing process. The periphery of a simple planar top heat spreader can in such an embodiment be encapsulated with the MPM molding material, and may be provided with a step-like re-entrant feature on the periphery (refer to re-entrant feature **1005** in the simple planar heat

spreader **1004** in FIG. **6D**) to allow for better mechanical integrity of the structure with less delamination from the molding compound.

[0097] An advantage of a structure as in FIGS. **6D**, **6E** is improved thermal performance. It is not necessary to have both a bottom package shield and a top heat spreader for all applications. Alternately one or the other may be adequate depending on the end product needs.

[0098] FIG. **7** shows, in a diagrammatic sectional view, another embodiment of a MPM according to the invention generally at **110**, in which a stacked-die LGA top package **1000** is stacked over a stacked-die BGA bottom package **408**, and the top and bottom packages are interconnected by wire bonding. In the embodiment illustrated in FIG. **7** the bottom BGA package **408** has two die in the stack, and the top LGA package has two die in the stack.

[0099] A structure having this configuration is particularly desirable, for example, for applications that require high memory density within a fixed footprint. The stacked die can be of the same or of differing types of memory including Flash, SRAM, PSRAM, *etc.*

[0100] Referring to FIG. **7**, top package **1000** is constructed substantially similarly to top package **1000** in FIG. **6A**, and like features are identified by like reference numerals. Particularly, the top package **1000** is a stacked die land grid array package, having die **1014**, **1024** separated by a spacer **1015** and stacked over a top package substrate. The top package substrate includes a dielectric layer **1012** having a metal layer on the upper substrate surface, and patterned to provide traces, for example **1011**, provided with attachment sites for wire bond interconnect of the top package substrate with the stacked die and for wire bond interconnect of the top package with the bottom package substrate. Lower die **1014** is attached to a die attach area of the top package substrate using an adhesive **1013** such as a die attach epoxy. Die **1014** is electrically connected to the top substrate by way of wire bonds **1016** connecting wire bond sites on the active surface of die with wire bond sites on selected traces **1011**. A spacer **1015** is affixed to the upper surface of the lower die **1014** using an adhesive (not shown in the FIG.), and upper die **1024** is affixed to the upper surface of the spacer **1015** using an adhesive (not shown). The spacer is selected to be sufficiently thick to provide clearance so that the overhanging margins of upper die **1024** do not impinge upon the wire bonds **1016**. Die **1024** is electrically connected to the top substrate by way of wire bonds **1026** connecting wire bond sites on the active surface of die with wire bond sites on selected traces **1011**. The assembly of stacked die and wire bonds over the top package substrate is encapsulated in a molding material **1017** providing a top package upper surface **1019**, and leaving marginal portions of the interconnect traces **1011** exposed. The top package **1000** may at this point be tested, and then stacked over the bottom package **408**, as described in detail below.

- 24 -

[0101] The bottom package **408** of MPM **110** is constructed similarly to the top package **1000**. Particularly, the bottom package **408** is a stacked die land grid array package, having die **444**, **454** separated by a spacer and stacked over a bottom package substrate. The bottom package substrate serves as the interconnect substrate for the completed MPM, and it can be constructed in a manner similar, for example, to the bottom substrate **412** of bottom package **400** of MPM **50** in FIG. **5A**. Particularly, in this embodiment the bottom package **408** includes a bottom package substrate **442** having at least one metal layer. Any of various substrate types may be used, including for example: a laminate with 2 - 6 metal layers, or a build up substrate with 4 - 8 metal layers, or a flexible polyimide tape with 1 - 2 metal layers, or a ceramic multilayer substrate. The bottom package substrate **442** shown by way of example in FIG. **7** has two metal layers **451**, **453**, each patterned to provide appropriate circuitry and connected by way of vias **452**. The lower die **444** is conventionally attached to an "upper" surface of the substrate using an adhesive **443**, typically referred to as the die attach epoxy, shown at **443** in FIG. **7**. The lower die is electrically connected to the bottom substrate by wire bonds **446** connecting wire bond sites in the active surface of the die **444** with wire bond sites on selected traces **451**. A spacer is affixed to the upper surface of the lower die **444** using an adhesive (not shown), and the upper die **454** is stacked over and affixed to the upper surface of the spacer using an adhesive (not shown). The spacer is selected to be sufficiently thick to provide clearance so that the overhanging margins of upper die **454** do not impinge upon the wire bonds **446**. The upper die **454** is electrically connected to the bottom substrate by wire bonds **456** connecting wire bond sites in the active surface of the die **454** with wire bond sites on selected traces **451**. The bottom package lower die **444** and upper die **454** and the wire bonds **446**, **456** are encapsulated with a molding compound **447** that provides protection from ambient and from mechanical stress to facilitate handling operations, and provides a bottom package upper surface onto which the top stacked die package **1000** can be stacked. Solder balls **418** are reflowed onto bonding pads on the lower metal layer of the substrate to provide interconnection to underlying circuitry of, for example, a motherboard (not shown in the FIGS.) of a final product. Solder masks **455**, **457** are patterned over the metal layers **451**, **453** to expose the underlying metal at bonding sites for electrical connection, for example the wire bond sites and bonding pads for bonding the wire bonds and solder balls **418**.

[0102] The top package **1000** may be tested, and then stacked onto a die attach area of the upper surface of the bottom package substrate, and affixed there using an adhesive **1103**. Electrical interconnect of the top and bottom packages is effected by wire bonds **1118** connecting exposed wire bond sites on the traces **1011** of the top package substrate with wire bond sites on traces **451** of the upper metal layer of the bottom package substrate. The MPM

assembly is then encapsulated in a molding **1107** to protect the package-to-package wire bonds and to provide mechanical integrity in the completed MPM **110**.

[0103] MPM having stacked die in the top package or in the bottom package, or in both the top and bottom packages, can be particularly for high memory small footprint applications.

5 A multi-package module of FIG. 7 can include, for example, a stacked die memory top package over a stacked ASIC bottom package; or, both top and bottom packages can be stacked die memory packages, making a high density memory module.

[0104] Other stacked die package configurations can be employed in a bottom or top stacked die package in MPM according to this aspect of the invention, depending for example
10 on the number of die in the stack, and upon the dimensions of the die in the stack. For example an upper die in a bottom package stack may have a smaller dimension than a lower die. In such a configuration there is no marginal overhang of the upper die over the wire bond attachment sites in the margin of the lower die, and so it is unnecessary to include a spacer between the adjacent die in the stack.

15 **[0105]** Other top package configurations can be stacked over a stacked die bottom package according to this aspect of the invention. A BGA top package, as shown for example in the embodiments of FIG. 5A, may be stacked over a stacked die bottom package.

[0106] For improved heat dissipation from a multi-package module having stacked die bottom package, as illustrated by way of example in FIG. 7, a heat spreader may be provided
20 over the top package. The top heat spreader is formed of a thermally conductive material having at least the more central area of its upper surface exposed at the upper surface of the MPM to ambient for efficient heat exchange away from the MPM. The top heat spreader may be, for example, a sheet of metal (such as copper), and it may be affixed to the MPM encapsulant during the molding material curing process. Or, the heatspreader may have a
25 generally planar portion over the top package, and a peripheral supporting portion or supporting members resting on or near the upper surface of the bottom package substrate.

[0107] Top heat spreaders as illustrated by way of example in FIG. 5D and FIG. 5E, can be suitable as well as top MPM heat spreaders in MPM having a stacked die bottom package (or having stacked die bottom and top packages).

30 **[0108]** With reference to the MPM construct of FIG. 7 and to the heat spreader in FIG. 5E, for example, the top heat spreader can be formed of a thermally conductive material having a generally planar central portion **544** situated over the top package, and peripheral supporting members **546** extending to the upper surface of the bottom package substrate **442**. The upper surface of the planar portion **544** is exposed to ambient at the MPM upper surface for efficient
35 heat exchange away from the MPM. The top heat spreader may be formed, for example, of a sheet of metal (such as copper), for example by stamping. The supporting members **546** can optionally be affixed to the upper surface of the bottom package substrate using an adhesive.

The multi-package module structure is protected by formation of a module encapsulant **1107**, and the heat spreader supporting members are embedded in the MPM encapsulant **1107** during the molding material curing process. A step like re-entrant feature **545** can be provided on the periphery of the planar upper portion **544** of the heat spreader to allow for better mechanical integrity of the structure with less delamination from the molding compound. In this embodiment the space between the lower surface of the heat spreader **544** and the upper surface **1019** of the top package molding **1017** is filled by a thin layer of the MPM molding.

[0109] Alternatively, a top heat spreader can be affixed to the upper surface of the top package molding. Referring to the MPM construct of FIG. 7 and to the heat spreader in FIG. 5D, for example the top heat spreader **504** can be a generally planar piece of a thermally conductive material having at least the more central area of its upper surface exposed to ambient for efficient heat exchange away from the MPM. The top heat spreader may be, for example, a sheet of metal (such as copper). Here, however, the top heat spreader **504** is affixed onto the upper surface **1019** of the upper package encapsulant **1017** using an adhesive. The adhesive may be a thermally conductive adhesive, to provide improved heat dissipation. Usually the top heat spreader is affixed to the top package molding after the top package molding has been at least partly cured, but before the molding material is injected for the MPM encapsulation **1107**. The periphery of the top heat spreader may be encapsulated with the MPM molding material. A step like re-entrant feature **505** can be provided on the periphery of the heat spreader **504** to allow for better mechanical integrity of the structure with less delamination from the molding compound.

[0110] As a further alternative, an MPM as in FIG. 7 can be provided with a simple planar heat spreader, with no supporting members, that is not attached to the upper surface of the top package molding. In such embodiments, the top heat spreader can be a generally planar piece of a thermally conductive material such as, for example, a sheet of metal (such as copper), and at least the more central area of the upper surface of the planar heat spreader is exposed to ambient for efficient heat exchange away from the MPM. Here, the space between the lower surface of the simple planar heat spreader and the upper surface **1019** of the LGA molding **1017** may be filled by a thin layer of the MPM molding, and such a simple planar heat spreader may be affixed to the MPM encapsulant **1107** during the molding material curing process. The periphery of such an unattached simple planar top heat spreader can be encapsulated with the MPM molding material, as in the attached planar heat spreader of FIG. 5D, and may be provided with a step-like re-entrant feature **505** on the periphery to allow for better mechanical integrity of the structure with less delamination from the molding compound.

[0111] As will be appreciated from the foregoing, in all its various aspects the invention features wire bonding as the z-interconnect method between stacked packages. Generally, all

LGAs stacked on a lower BGA must be smaller (in at least one dimension in the x - y plane) than the BGA to allow space at the periphery for the wire bonds. The wire diameter typically is of the order of 0.025 mm (0.050 to 0.010 mm range). The wire distance to the LGA substrate edge can differ in various embodiments, but is no less than a wire diameter. The relative sizes of BGA and LGA are determined primarily by the maximum die size in each. The die thickness and mold cap thickness primarily determine how many die can be stacked in one package.

[0112] Processes for making BGA packages and LGA packages for use in the invention are well established in the industry for both the wire bonded and the flip chip types of packages.

[0113] Testing of BGAs is well established in the industry, and typically is done by accessing contact to the solder ball pads. The LGAs can be tested in either of two ways, namely by accessing the LGA pads on the lower surface of the LGA of the substrate, similar to the pads of the solder balls in a BGA; or by accessing the z-interconnect pads on the upper surface of the substrate. The completed MPM assembly can be tested in the same as for testing BGAs.

[0114] The MPM assembly process is similar for the configurations according to the various aspects of the invention. Generally, the process includes steps of providing a first molded package including a first package substrate and at least one die attached to the first package substrate, dispensing adhesive onto an upper surface of the first molded package, placing a second molded package including a second package substrate and at least one die such that a lower surface of the second substrate contacts the adhesive on the upper surface of the first package, during the adhesive, and forming z-interconnects between the first and second substrate. Advantageously, the packages can be tested prior to assembly, and package is not meeting requirements for performance or reliability can be discarded, so that first packages and second package is tested as "good" are used in the assembled module.

[0115] FIG. 8 is a flow diagram showing a process for assembly of a multi-package module as shown for example in FIG. 6A or FIG. 6B. In a step 1702, an unsingulated strip of die-up flip chip ball grid array packages is provided. The flip chip interconnects are protected by an underfill or molding between the die and the die attach surface of the bottom substrate, and so no overmolding is required. The BGA packages in the strip preferably are tested (as indicated in the FIG. by *) for performance and reliability before they are taken to subsequent steps in the process. Only packages identified as "good" are subjected to subsequent treatment. In a step 1704, adhesive is dispensed over the upper surface of the substrate on "good" BGA packages. In a step 1706, singulated second packages are provided, which may be stacked die packages, as for example in FIGS. 6A and 6B. The singulated second packages are protected by a molding, and preferably are tested (*) and identified as "good". In a step 1708, a pick-and-place operation is carried out to place "good" second packages on the

adhesive over the substrate on the "good" BGA packages. In a step 1710, the adhesive is cured. In a step 1712, a plasma clean operation is performed in preparation for a step 1714 in which wire bond z-interconnections are formed between the stacked top (stacked die) and bottom die-up flip chip BGA packages. In a step 1716, an additional plasma clean may be performed, followed by the formation of the MPM molding in a step 1718. In a step 1720, the second-level interconnect solder balls are attached to the underside of the module. In a step 1722, the completed modules are tested (*) and singulated from the strip, for example by saw singulation or by punch singulation, and packaged for further use.

[0116] FIG. 9 is a flow diagram showing a process for assembly of a multi-package module as shown for example in FIG. 7. In a step 1802, an unsingulated strip of stacked die ball grid array packages is provided. The stacked die BGA packages are molded, providing an upper package surface. The BGA packages in the strip preferably are tested (as indicated in the FIG. by *) for performance and reliability before they are taken to subsequent steps in the process. Only packages identified as "good" are subjected to subsequent treatment. In a step 1804, adhesive is dispensed over the upper surface of the substrate on "good" stacked die BGA packages. In a step 1806, singulated second packages are provided, which may be stacked die packages, as for example in FIG. 7. The singulated second packages are protected by a molding, and preferably are tested (*) and identified as "good". In a step 1808, a pick-and-place operation is carried out to place "good" second packages on the adhesive over the substrate on the "good" BGA packages. In a step 1810, the adhesive is cured. In a step 1812, a plasma clean operation is performed in preparation for a step 1814 in which wire bond z-interconnections are formed between the stacked top (stacked die) and bottom die-up flip chip BGA packages. In a step 1816, an additional plasma clean may be performed, followed by the formation of the MPM molding in a step 1818. In a step 1820, the second-level interconnect solder balls are attached to the underside of the module. In a step 1822, the completed modules are tested (*) and singulated from the strip, for example by saw singulation or by punch singulation, and packaged for further use.

[0117] As will be appreciated, individual ones of the various steps in the processes according to the invention can be carried out, according to the methods described herein, using substantially conventional techniques, with straightforward modification, as described herein, of conventional fabrication facilities. Such variation of conventional techniques and modification of conventional fabrication apparatus as may be required can be accomplished using the description herein without undue experimentation.

[0118] Other embodiments are within the following claims.